

5/20
J
E-08-02
DART AEROSPACE LTD

Work Order:

23044

Description: ~~Long~~ ^{Short} Pin Bracket

Part Number:

D3330-11 ~~B~~

Dwg: D3330 Rev. A

PAGE 9

Qty:

19 ~~20~~

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	J	05.04.15	20
2	MV	Cut blanks: 2.500" x 1.000" x 3.00" long (+/-0.030) Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel (M1010-B2.500x01.000) Identify for D3330-11 Batch: <u>M16634</u>	E	05.05.02	20
3	MV	Machine as per Folio FA479 and Dwg D3330 Identify as D3330-11	SD	05.05.03	20 19
4	QC2	Inspect parts as they come off the CNC machine	SD	05.05.03	20 19
5	QC8	Second check	R	05.05.04	19
6	MV	Deburr	SD	05.05.03	20 19
7	QC5	Inspect work to Step 6	E	05.05.04	19
8	ST	Identify and Stock	CPL	05.05.04	19
9	AC	Cost / part: <u>17.38</u>	SAC	05.05.05	19
10	DC	Close W/O <u>17.70</u> Inspect Level 21	J	05.05.11	19

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	J

RELEASED
05-01-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
	N/A	AS shown		05-05-04			

NCR: 23044		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-05-04	3	1 scrap - drill wrong side operator error		scrap: destroy	SD 05-05-04	2 05-05-04		2 05-05-04
		1 scrap - .500 dimension is .524 .014 over tol.	SD 05-05-04	OK TO USED.	SD 05-05-04	2 05-05-04	SD 05-05-04	2 05-05-04

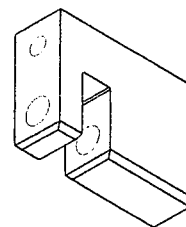
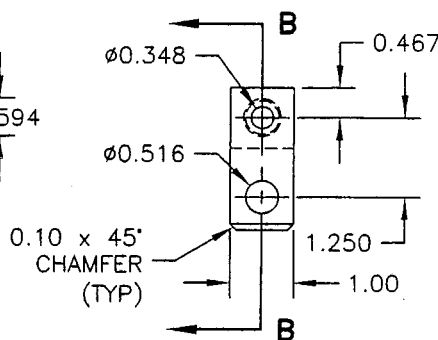
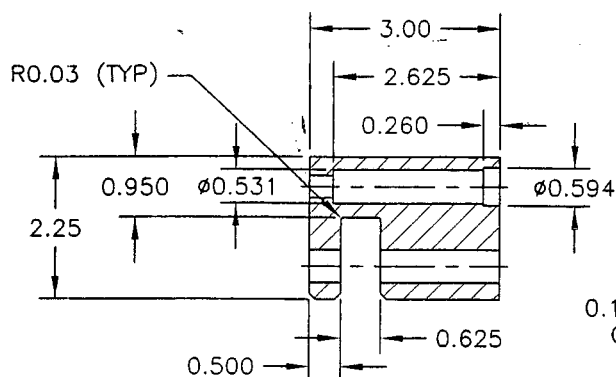
Part No: D3330-13 PAR #: _____ Fault Category: Prod/machined parts NCR: Yes No DQA: SD Date: 05-05-04

NOTE: Date & initial all entries

QA: N/C Closed: SD Date: 05-05-11

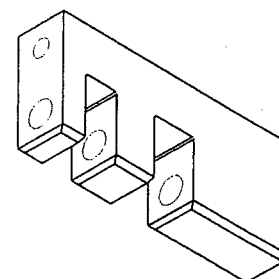
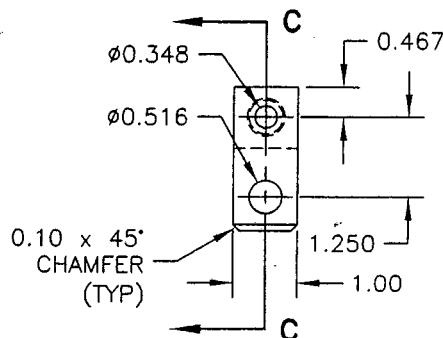
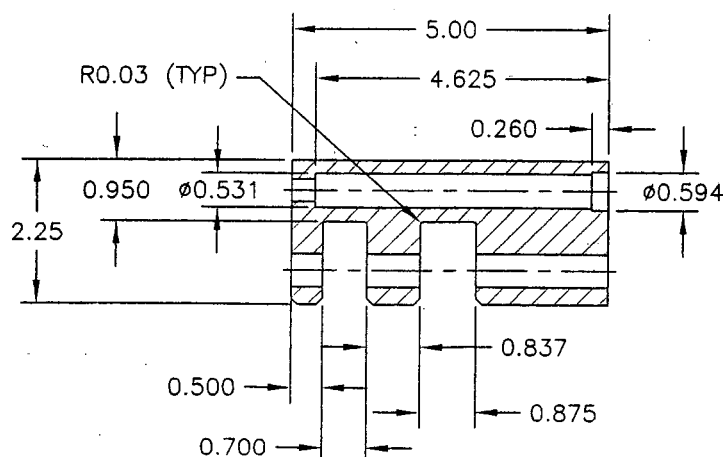
DART
PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED	DRAWING NO. D3330	REV. B SHEET 9 OF 9
DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:3



SECTION B-B

D3330-13 SHORT PIN BRACKET



SECTION C-C

D3330-11 LONG PIN BRACKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK, STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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ENGINEERING

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WITHOUT NOTICE

WORK ORDER

NO. 23044

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 12, 2005
02:25 pm

Work Order No : 0023044
Project Name : D3330-11
Project For : WK520
Work Order Type : Main
Main WO Number :
House Part Number : D3330-11
Description : Long Pin Bracket
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 04-12-05
Est Finish Date : 05-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

DART AEROSPACE LTD		Work Order: 23044
Description: Short Pin BRACKET		Part Number: D3330-13
Inspection Dwg: D3330 Rev: B.		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.00	± 0.030	3.030	✓			cut size
2.625	± 0.010	2.635	✓			CANNOT MEASURE ACCURATELY
0.260	± 0.010	0.262	✓			
0.594	$\begin{matrix} +0.005 \\ -0.000 \end{matrix}$	0.594	✓			
0.625	± 0.010	0.622	✓			
0.500	± 0.010	0.506	✓			
2.25	± 0.030	2.25	✓			
0.531	$\begin{matrix} +0.005 \\ -0.000 \end{matrix}$	0.531	✓			
0.950	± 0.010	0.950	✓			
0.348	$\begin{matrix} +0.005 \\ -0.000 \end{matrix}$	0.348	✓			
0.467	± 0.010	0.458	✓			
1.250	± 0.010	1.253	✓			
1.00	± 0.030	0.999	✓			mat. thickness.
0.10x45°	± 0.030	0.095x45°	✓			
0.516	$\begin{matrix} +0.005 \\ -0.000 \end{matrix}$	0.516	✓			

Measured by: <i>EN</i>	Audited by: <i>SD</i>	Prototype Approval: <i>N/A</i>
Date: 05/05/02	Date: 05.05.03	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	